

78273

Wednesday, January 04, 2012 1:36:37 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/4/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/9/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: *mf* Date: *12-01-04*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Insp. Stamp

Revision Nbr

D3783

Rev A

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

1-assemble as per dwg D3783

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 78273

78273

Page 2

Wednesday, January 04, 2012 1:36:37 PM

Item ID: D3783-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lateral Brace Assembly
Start Date: 1/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/9/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|
| 124 | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 | 0.00 | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|

124

Powdercoat

Powder Coating

Memo

Mask inside D3765-1 clevis

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

9:00
320 °F
9:30

IXM-L 12/01/07

| | | | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|
| 127 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|

127

QC

Quality Control

Memo

12/01/07

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 130 | Identify as per dwg & Stock Location: G.A | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

130

Packaging

Packaging

Memo

W/O
68859

EP 12/01/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78273***78273***

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Wednesday, January 04, 2012 1:36:37 PM

Item ID: D3783-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lateral Brace Assembly

Start Date: 1/4/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/9/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

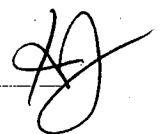
140

QC

Memo

0.00

Quality Control

12/1/10 
ME
12-01-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 04, 2012 1:36:36 PM

Page 1

Work Order ID: 78273

Parent Item: D3783-041

Parent Item Name: Lateral Brace Assembly

Start Date: 1/4/2012

Required Date: 1/9/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.a as per dwg DD verified by:EC IPP RevC: add powder coat for ease of manufacturing DD 10.01.13 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| AN5-13A Bolt | | Purchased | No | | | 110 | Each | 66.0000 | 2 | 2 | SB | 12/01/04 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | GA | | 20 | | | | | | | |
| | | | | 116003 | | 20 | | | | | | | |
| | | | | ST338 | | 46 | | | | | | | |
| | | | | 118983 | | 46 | | | | | | | |
| AN960JD516 Washer | NAS1149D0563J | Purchased | No | | | 110 | Each | 0.0000 | 4 | 4 | SB | 12/01/04 | |
| D3765-1 Clevis | | Manufactured | No | | | 110 | Each | 8.0000 | 2 | 2 | SB | 12/01/04 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST243 | | 8 | | | | | | | |
| | | | | 75028 | | 8 | | | | | | | |
| D3769-1 Tube | | Manufactured | No | | | 110 | Each | 2.0000 | 1 | 1 | SB | 12/01/04 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST251A | | 2 | | | | | | | |
| | | | | 60454 | | 2 | | | | | | | |
| MS21042L5 Nut | | Purchased | No | | | 110 | Each | 2,080.0000 | 2 | 2 | SB | 12/01/04 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST300 | | 2080 | | | | | | | |
| | | | | 116105 | | 5 | | | | | | | |
| | | | | 116548 | | 43 | | | | | | | |
| | | | | 117611 | | 50 | | | | | | | |
| | | | | 118179 | | 476 | | | | | | | |
| | | | | 118910 | | 6 | | | | | | | |
| | | | | 119109 | | 1500 | | | | | | | |

Dart Aerospace Ltd

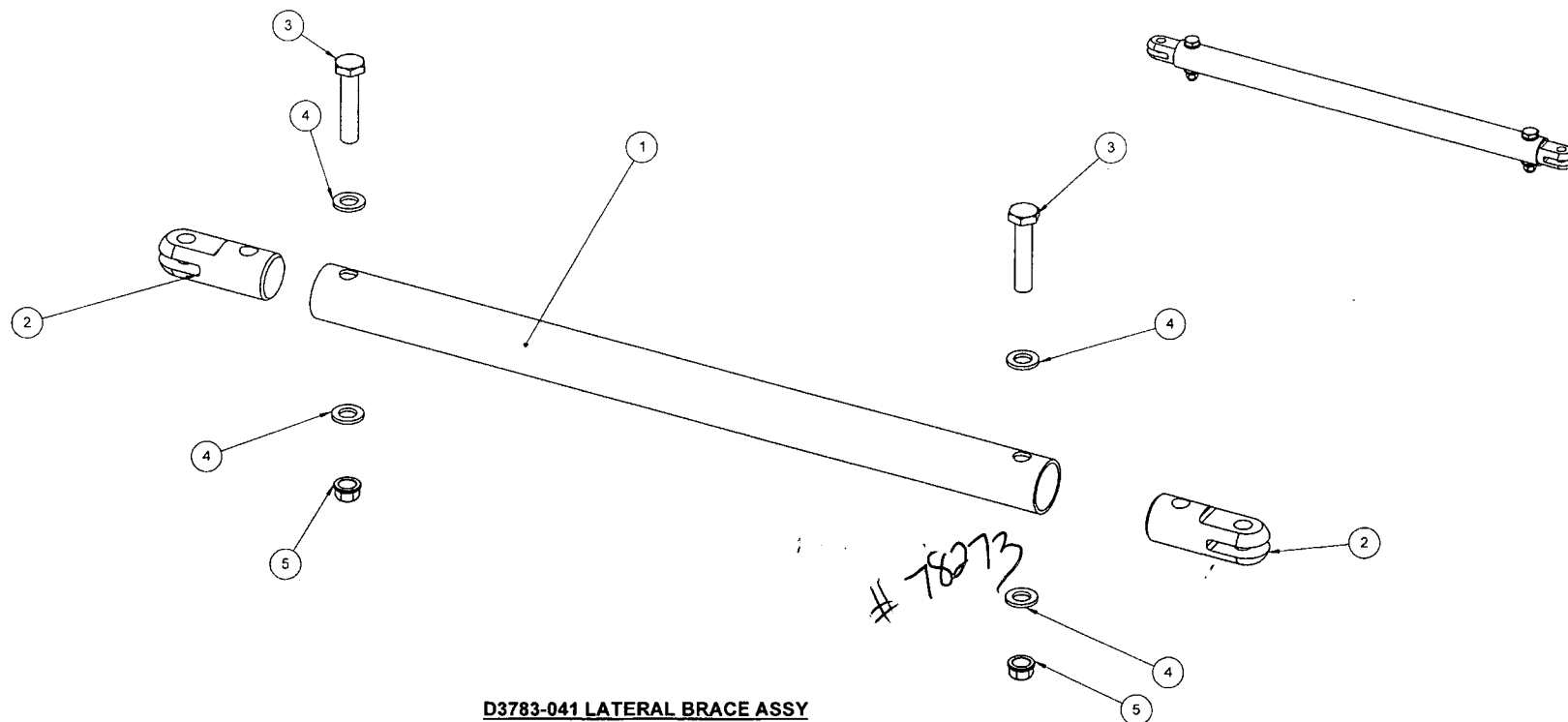
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NOTE: Date & initial all entries



D3783-041 LATERAL BRACE ASSY

| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. (-041) |
|----------|---------------|---------------------|-------------|
| 1 | D3769-1 | TUBE | 1 |
| 2 | D3765-1 | CLEVIS | 2 |
| 3 | AN5-13A | BOLT | 2 |
| 4 | NAS1149D0568J | WASHER (AN960JD516) | 4 |
| 5 | MS21042L5 | NUT | 2 |

RELEASED
08.06.04

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.52 lbs

| | | | | | |
|--|-------------|-----------------------------|--|--|----------|
| A | | NEW ISSUE | | HS | 08.06.04 |
| REV. | DESCRIPTION | | | BY | DATE |
| DESIGN | HS | DART AEROSPACE LTD | | REV. A | |
| DRAWN | HS | HAWKESBURY, ONTARIO, CANADA | | SHEET 1 OF 3 | |
| CHECKED | | DRAWING NO. D3783 | | TITLE | |
| MFG. APPR. | | | | SCALE | |
| APPROVED | | | | NTS | |
| DE APPR. | | | | BRACE ASSEMBLY | |
| DATE | 08.06.04 | | | COPYRIGHT © 2008 BY DART AEROSPACE LTD | |
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